

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002382**Date Inspected:** 02-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** MaKhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** PQR test plate**Summary of Items Observed:**

Reviewing Radiographic Testing (RT) film result for PQR (SW4-1): Caltrans Quality Assurance Inspector (QAI) Mr. Wai Pau traveled to Nikko Inspection Service (NIS) office, to review radiographic testing (RT) film result of AWS standard PQR welding test #SJ-2942-WP-5 (test plate SW4-1). Total two packages of x-ray film have been submitted to Caltrans reviewing, one is x-ray test before post weld heat treatment (PWHT) and other one is x-ray test after PWHT. Based on Caltrans QA observation, the x-ray films of PQR welding test were appeared to be in general compliance with the requirements of AWS D1.5 2002 and Caltrans contract document.

Witnessing AWS D1.5 standard welder qualification welding test: Caltrans QAI representative Mr. Wai Pau witnessed a welder qualification test. The qualification welding tests utilizing the Shielded Metal Arc Welding (SMAW) process were conducted by welders performed in the vertical position (3G). The welder test names are Mr. Maso Yamashita (73-4195). The material used for the welder qualification test specimens was reported by JSW Welding Engineer Mr. Jomio Imai as ASTM A 709M-HPS-485WT plate having a wall thickness measurement of 25mm. The weld joint design used butt joint, single-V-groove weld with 25mm backing bar. The proper filler metal used in the test for SMAW is Hoballoy 9018-M with 5mm diameter electrode made by Hobart Brothers, USA. The SMAW welding process and parameters have been monitored and recorded by CWI inspectors Mr. Chung Kuan. Based on Caltrans QA observation, the welder qualification tests appeared to be in general compliance with requirements of AWS D1.5 2002 Section 5 and Caltrans contract documents. A Caltrans Lot# B88-088-08 was assigned on this welder test for tracking propose.

Summary of Conversations:

As Note within the report above.

Comments

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer (858)697-6363, who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Brasel, Ron	QA Reviewer
